

Work Order ID 77464

December-08-11 7:57:46 AM

77464

Page 1

Item ID: D3826-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib / Gusset Assembly
 Start Date: 08/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 14/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.C.S Date: 11/12/08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3826	Rev B								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod Batch: <u>114649</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

Pl 11.12.18 *6x* *Ø*

11.12.19 *⑥*

Sumzlig *(46)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77464

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Item ID: D3826-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib / Gusset Assembly
 Start Date: 08/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 14/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>W/A</i> Memo	0.00 0.00				<i>6x</i>	<i>Ø</i>		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/12/2011</i> <i>MF 11-12-20</i>

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77464

77464

Parent Item: D3826-041

D3826-041

Parent Item Name: Rib / Gusset Assembly

Start Date: 08/12/2011

Required Date: 14/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2235-1		Manufactured	No			100	Each	13.0000	1	6			
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D2235-1

Basket Rib

**

377230 → 2x 11/12/14

Location	Loc Qty	Loc Code
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WA005	13	
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66895	4	
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73200	9	
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D3929-041		Manufactured	No			100	Each	9.0000	1	6			
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D3929-041

Gusset Assembly

**

4x 11/12/14

Location	Loc Qty	Loc Code
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WA005	9	
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72795	1	
-------	---	--

74997	8	
-------	---	--

D3929-042		Manufactured	No			100	Each	10.0000	1	6			
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D3929-042

Gusset Assembly

**

1x 5x 11/12/14

Location	Loc Qty	Loc Code
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WA005	10	
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72797	2	
-------	---	--

74996	8	
-------	---	--

2x 4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

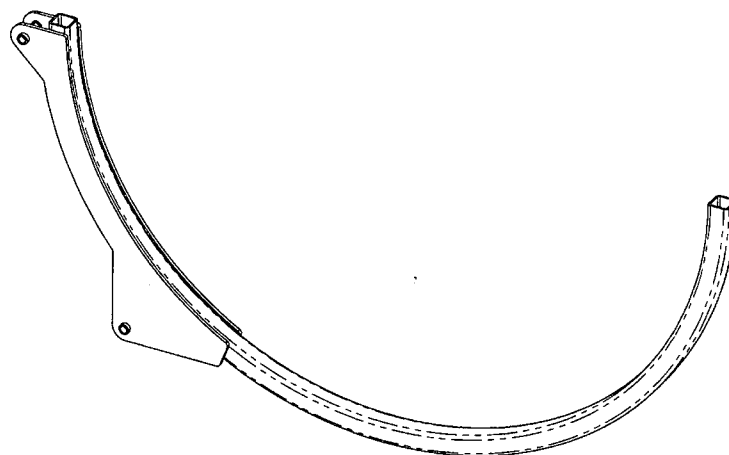
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△B



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNIVERSITY OF MICHIGAN
SUBMIT
WITH
WORK
NO. 77464 M.L.J
11/12/08

RELEASED
8/10/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

△B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	16	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	15		
CHECKED	14	DRAWING NO.	REV. B
MFG. APPR.	13	D3826	SHEET 1 OF 2
APPROVED	12	TITLE	SCALE
DE APPR.	11	RIB/GUSSET ASSY	NTS
DATE	09.04.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

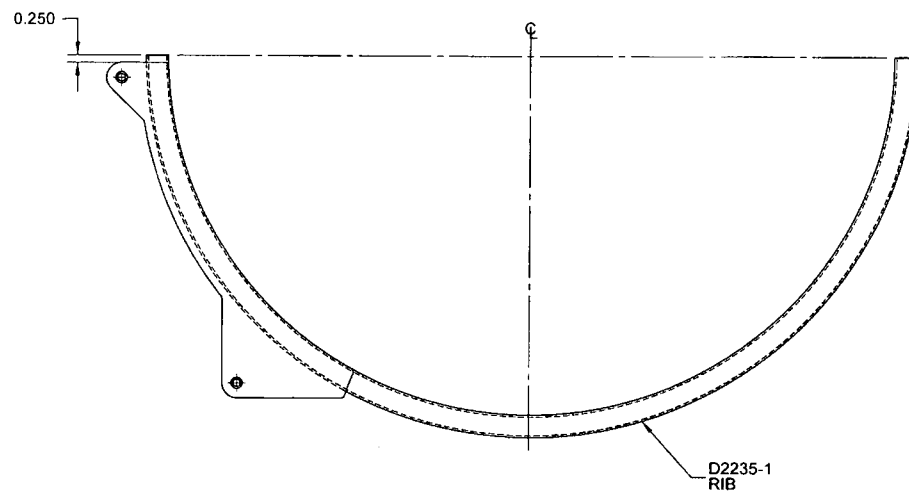
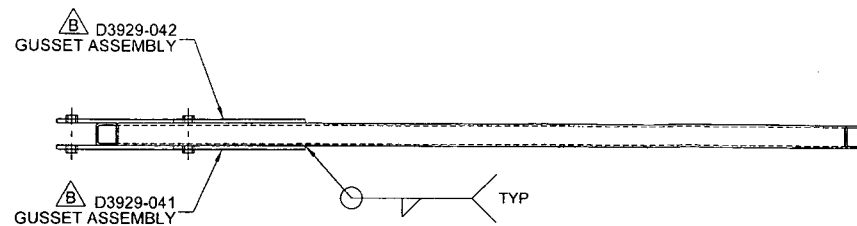
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NOTE: Date & initial all entries

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D3826-041 RIB/GUSSET ASSY

RELEASED
3/6/16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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